

Date: Wednesday, 7/11/2007 2:49:33 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : DOUBLER
Job Number : 33494D
Estimate Number : 10296
P.O. Number : *N/A*
This Issue : 7/11/2007 S.O. No. : *N/A*
Prsht Rev. : *NC*
First Issue : *N/A* Type : MACHINED PARTS
Previous Run : 30158D
Written By : *[Signature]*
Checked & Approved By : *[Signature]*
Comment : Est Rev. A New Issue 05-11-06 JLM
*Est: B 06.11.15 waterjet EC

Part Number : D32203
Drawing Number : D3220 REV A1
Project Number : N/A
Drawing Revision : A1
Material : *N/A*
Due Date : 8/5/2007 Qty: 20 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M2024T3S050 2024-T3 .050 sheet



Comment: Qty.: 0.6233 sf(s)/Unit Total : 12.4656 sf(s)

Material: 2024-T3 (QQ-A-250/4) 0.050" thick

(M2024T3S.050

Identify for D3220-3

Batch: *M103321 LB 07-07-30*

2.0 WATER JET FLOW WATER JET



Dwr AL AL LB 07-07-30
Prj AL AL



Comment: FLOW WATER JET

Debur = SAD 07/07/30 (20) SAD 07/07/29

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

LB 07-07-30 (20)
SAD 07/09/29

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

End 07/07/30 (20)
(PTO)

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

AD 0707-31 (20)

6.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

[Signature]
07/08/01 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 07/08/01
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
0707-30	1.0	Qty 20 parts scrap. 5052 material was used. Batch: H4894.	<i>[Signature]</i> 05/01/02	See NCR 192 Replace the material with correct type. Qty 20	<i>[Signature]</i> 07/07/30	<i>[Signature]</i> 07/07/30	<i>[Signature]</i> 05/01/02	<i>[Signature]</i> 0707-30

NOTE: Date & initial all entries

Date: Wednesday, 7/11/2007 2:49:33 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 33494D

Part Number: D32203

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Eff 07/08/01 (20)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(20)

Comment: FINAL INSPECTION/W/O RELEASE

07/08/01

Job Completion



Jul 07-07-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

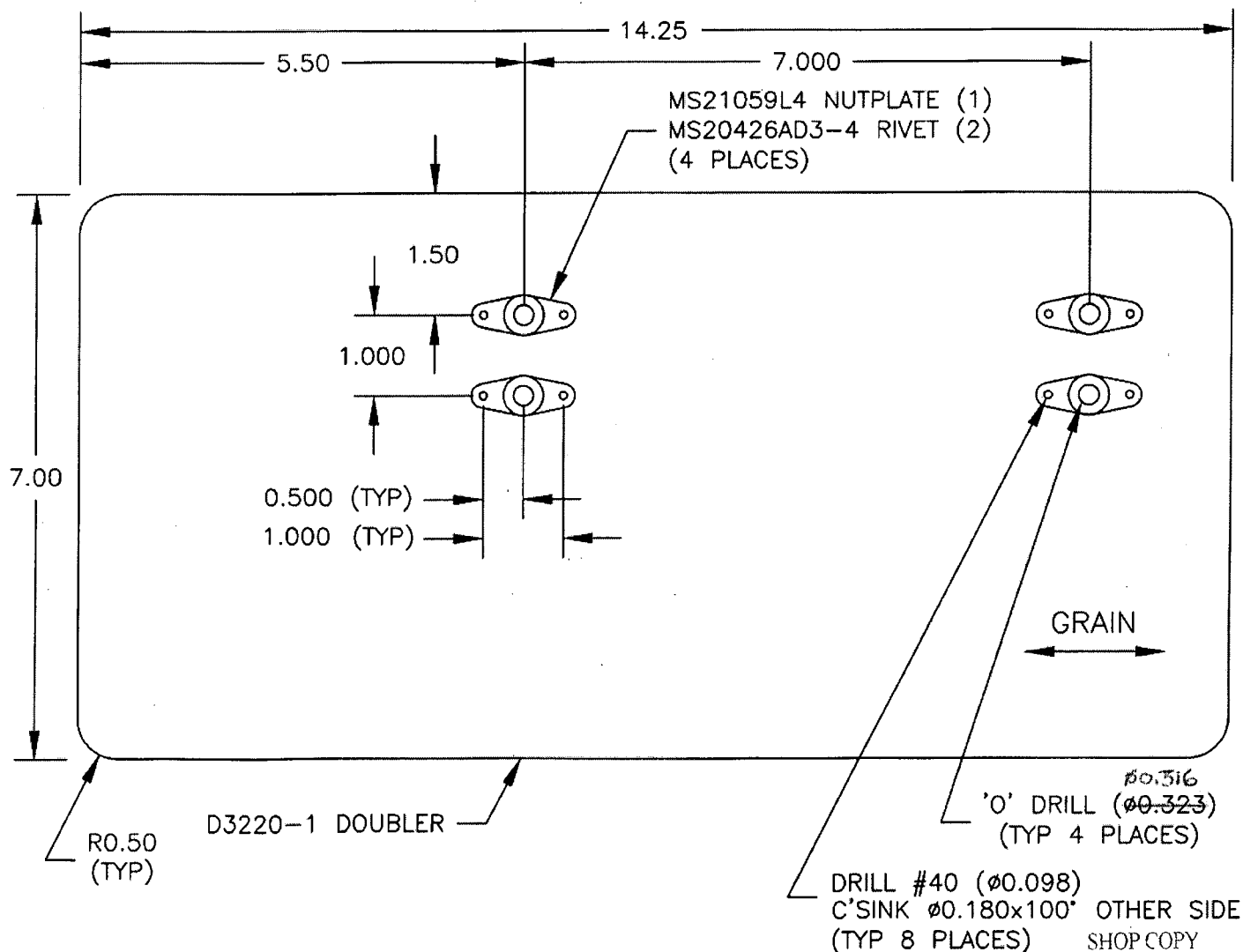
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

initial all entries



DESIGN	<i>#</i>	DRAWN BY	<i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>#</i>	APPROVED	<i>#</i>	DRAWING NO. D3220	REV. A SHEET 1 OF 2
DATE	03.10.16			TITLE DOUBLER	SCALE 1:2
A	03.10.16			NEW ISSUE	
A1	<i>CP</i>	<i>#</i>	03.11.13	CORRECTED DIM	

RELEASED
03.11.14 *#*



D3220-041 (SHOWN) / -042 (OPPOSITE) DOUBLER ASSEMBLY (D3220-1 DOUBLER)

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.050 THICK
(REF DART SPEC. M2024T3S.090)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *33494 ID*

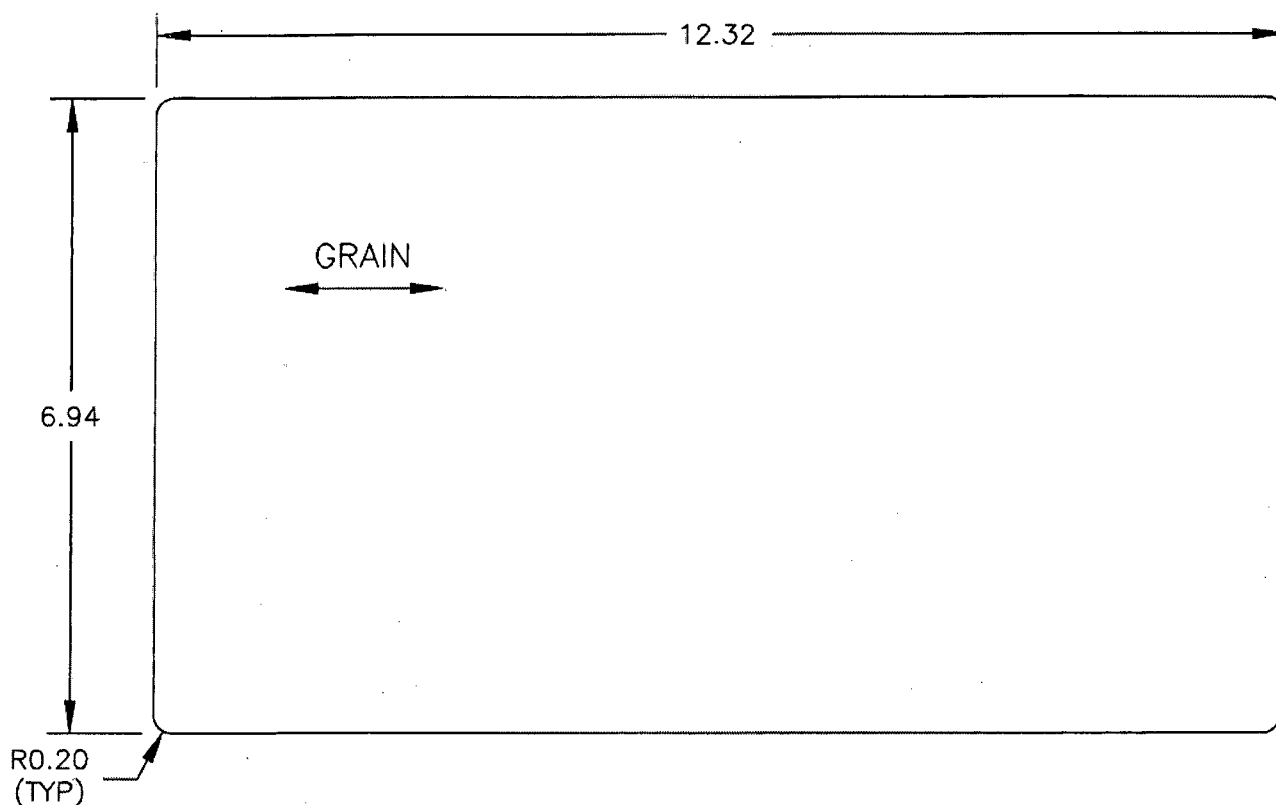
Copyright © 2003 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3220	REV. A SHEET 2 OF 2
DATE 03.10.16		TITLE DOUBLER	SCALE 1:2

RELEASED
03 11 14 #



D3220-3 DOUBLER

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.050 THICK
(REF DART SPEC. M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 33494-D

Copyright © 2003 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Non-Conformance Report				NCR 192^A	
Raised by: <u>Jason Murchel</u>		Source: <u>Q.C.</u>		Sheet No. <u>1</u> of <u>1</u>	
Non-Conforming Dept./Supplier: <u>Production/Small Fab/Water Jet.</u>				Date: <u>07-07-30</u>	
Product/Service: <u>D3220-3 divider</u>				Priority: HIGH LOW	
Area of Standard:		Section A Description of Non-Conformance The wro and drawing clearly ask for 2024-T3 0.050" material, and the employee used 5052 0.050" material. Root Cause Material 5052 was placed in the 2024 slot.			
QSI					
QSP					
QSPM					
Documents:					
P/O					
Invoice					
W/O					
Batch No. <u>33494</u>					
TSR					
Drawing					
Forward to Director, Quality Assurance on completion of this box					
DQA: Section B: Indicate who is responsible for creating C/A, and a completion date. Section C: Indicate who will verify completion of C/A.					
Section B		Responsible for Investigation/CA: <u>L. Lopez</u> To be done by: <u>07-07-30</u>			
Corrective Action					
No	Initial	Action Description	Responsible	Due date	Sign/Date
1	J.M.	Scrap the material on the wro, and give the material to Production Small Fabrication, for press brake setups, and tooling. Identify the material for tooling, and set up use only.	J. Murchel	07-07-30	[Signature] 07-07-30
2	J.M.	Verify the material that is being pulled in accordance with the work orders and drawings. <u>SAM 07-07-30</u> Inform employee to place the material in it's correct location. <u>DO NOT MIX.</u> <div style="text-align: center;"><u>IB</u></div>	J. Murchel	07-07-30	[Signature] 07-07-30
Preventive Action Required: NO YES # _____			Fault Category: <u>Prod - Sm. FAB</u>		
Section C		Responsible for Verification of CA: <u>D. Trepanice</u>			
Verification of C/A					
No	Verification Method		Sign	Date	Forward to DQA on Completion of Verification
1	Scrap material is now with small fab and identified as tooling and set up use only.		[Signature]	07/08/24	DQA: <u>[Signature]</u>
2	Employees have been re-trained		[Signature]	07/08/24	Date: <u>07.08.29</u>
QA Purposes only			N/C Closed		Date _____